



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2877
Job Sheet 179683



Part No: D2877

Job Qty: 24 ea

Part Name: Saddle Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP B 00.05.19 Added inspect level 8 EC IPP C IPP Rev:D Now M6061-T6 06-06-23 JLM IPP
Rev:E Updated Thickness as per Rev B 06-09-18 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	24 Ea	7/18/18	7/18/18	0.00	0.00	Start Up Waterjet		SC 180703
100	Waterjet	24 pcs	7/18/18	7/18/18	0.00	0.83	Waterjet1		SL 180703
120	QC	24 pcs	7/18/18	7/18/18	0.00	0.00	QC8		38
130	HandFinish	24 pcs	7/18/18	7/18/18	0.00	0.22	HandFinish1		SA 18-07-06
140	QC	24 pcs	7/18/18	7/18/18	0.00	0.00	QC7-1		38
150	Packaging	24 pcs	7/18/18	7/18/18	0.00	0.00	Packaging3		6 JUL 24 2018
160	QC21-SA	24 Ea	7/18/18	7/18/18	0.00	0.00	QC21		DAS 21 JUL 24 2018

Part Op Descriptions: 100 - 1-Cut as per Dwg D2884 2-Tumble ,Deburr if necessary

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.125	6061-T6 .125 Sheet	1.4568 sf (.0607 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.125	1	92	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle Spacer	0.980Inches ± 0.030	1.010 0.950	0.986	
2	Saddle Spacer	0.060Inches ± 0.030	0.090 0.030	0.063	Radius
3	Saddle Spacer	0.300Inches ± 0.030	0.330 0.270	0.306	Radius
4	Saddle Spacer	1.000Inches ± 0.030	1.030 0.970	1.002	
5	Saddle Spacer	0.250Inches + 0.030 - 0.000	0.280 0.250	0.251	
6	Saddle Spacer	0.257Inches + 0.005 - 0.000	0.262 0.257	0.260	Diameter

QA Closed: _____ Date: _____

Work Order update only

[illegible]

7

Saddle Spacer

0.125Inches $\pm$ 0.005

0.130

thick

0.120

0.125

Plex 6/21/18 6:58 AM Dart.lajeunesse.marie